

Date: Monday, 10/22/2007 10:34:19 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 35257	
Estimate Number : 12729	
P.O. Number : N/A	Part Number : D353539
This Issue : 10/22/2007 S.O. No. : N/A	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 33629	Material : N/A
	Due Date : 10/31/2007
Written By : <u>HB 07-10-22</u>	Qty: 26 Um: Each
Checked & Approved By : <u>HB 07-10-22</u>	
Comment : Est Rev: A New Issue 07-02-15 JLM	
Est Rev: B As per Rev B 07-08-31 JLM	Verified By: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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25.9636



Comment: Qty.: 0.9986 sf(s)/Unit Total : 15.9768 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 105871 HB 07-10-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

HB 07-10-23

(26)

2-Deburr if necessary

HB 07-10-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-10-23



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

HB 07-10-23

HB 07-10-23

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

HB 07-10-31

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/11/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 10:34:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35257

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/31 (26) centers

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

BR 07-01-02

(26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 07-11-02

(26)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FR-16*

BR 07-11-02

(26)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20111105

Job Completion



C207111105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35257
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	X			
32.775	+/-0.010	32.775	X			
29.275	+/-0.010	29.275	X			
25.775	+/-0.010	25.775	X			
23.250	+/-0.010	23.250	X			
19.750	+/-0.010	19.750	X			
17.750	+/-0.010	17.750	X			
14.250	+/-0.010	14.250	X			
9.500	+/-0.010	9.500	X			
4.750	+/-0.010	4.750	X			
2.000	+/-0.010	2.000	X			
5.00	+/-0.030	5.00	X			
9.00	+/-0.030	9.00	X			
28.00	+/-0.030	28.00	X			
Ø0.188	+0.005/-0.001	.189	X			
1.885	+/-0.010	1.885	X			
0.300	+/-0.010	.302	X			
0.300	+/-0.010	.304	X			
0.038	+/-0.010	.038	X			

Measured by: RB	Audited by: CJ	Prototype Approval:	N/A
Date: 07-10-23	Date: 07/10/23	Date:	N/A

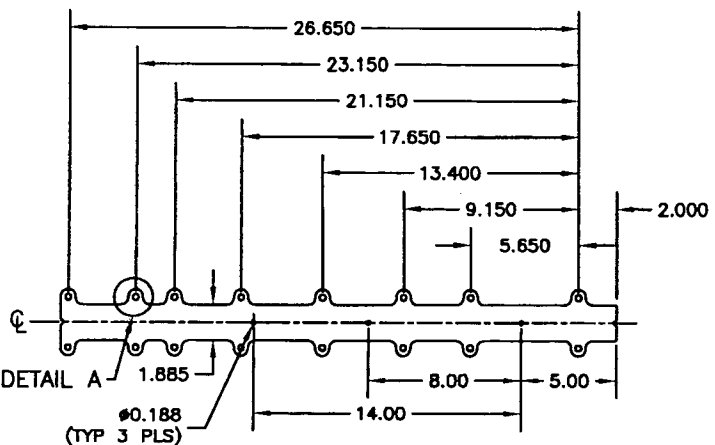
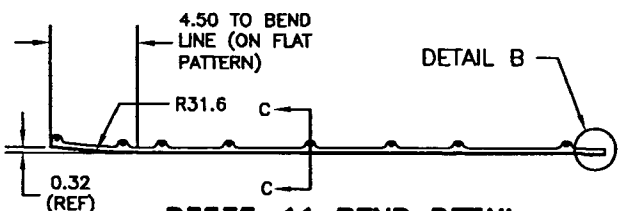
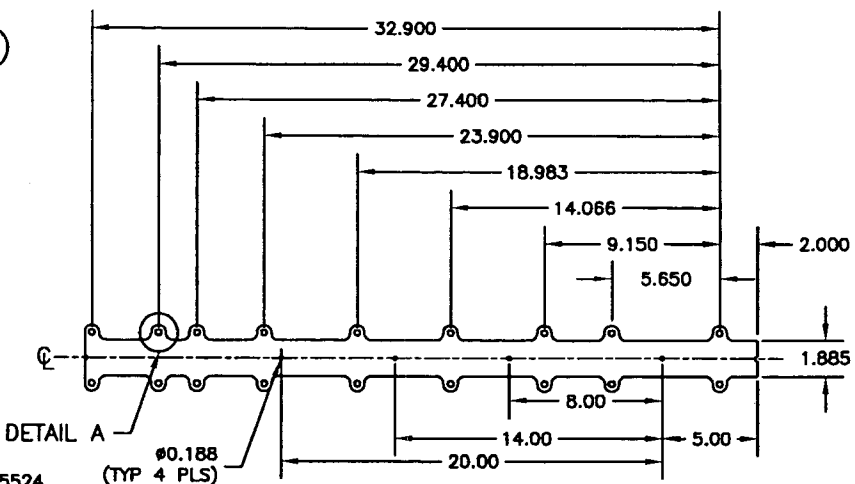
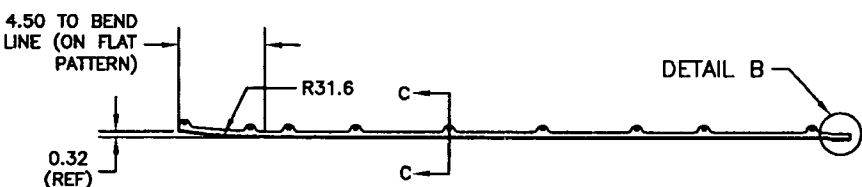
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

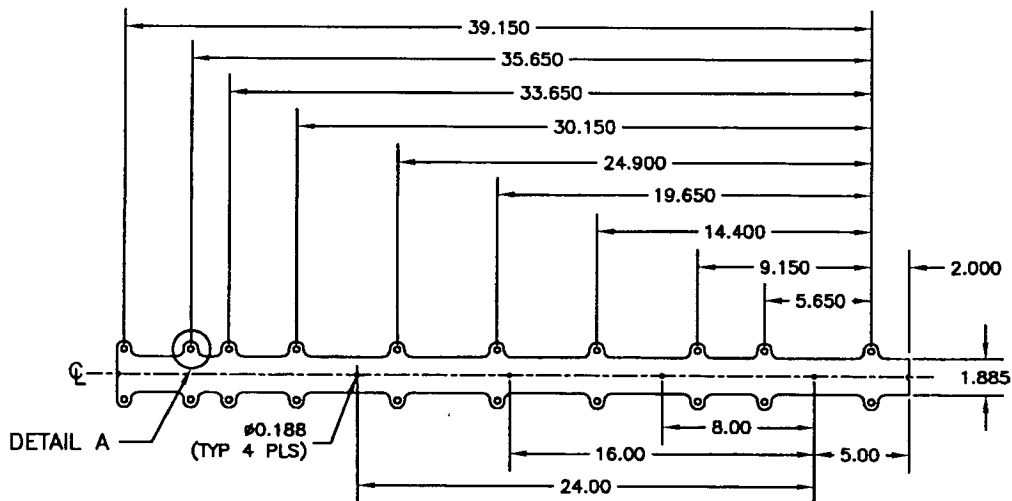
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WORK ORDER
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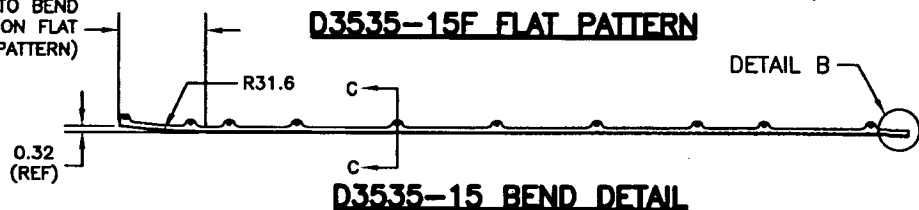
07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
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#	#	D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

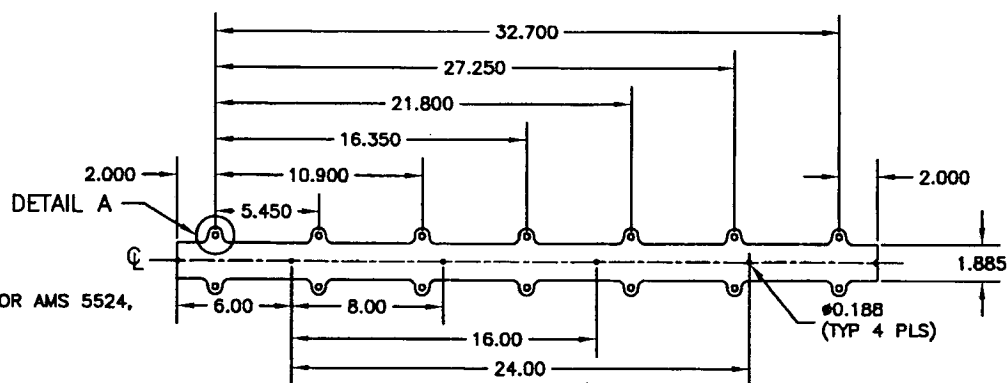


4.50 TO BEND
LINE (ON FLAT
PATTERN)

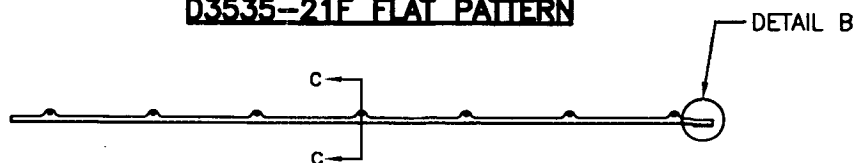
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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NOTES

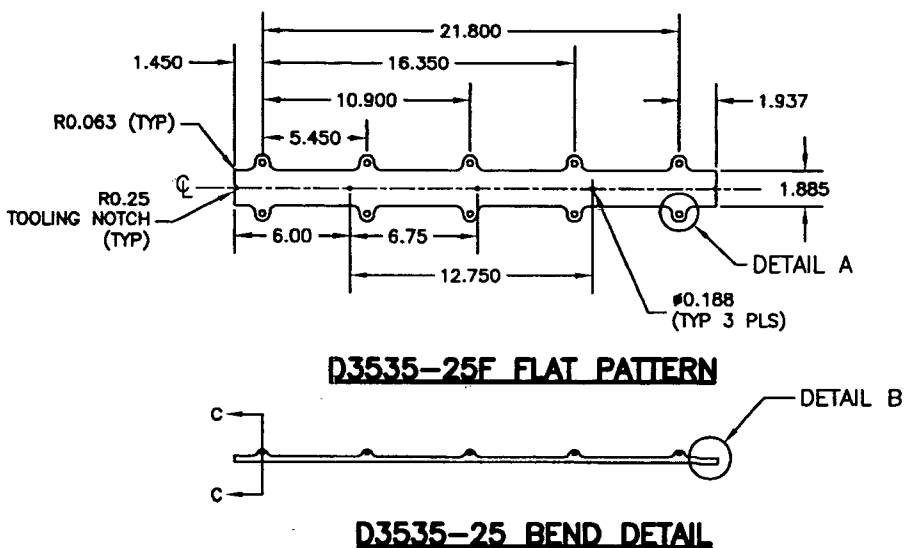
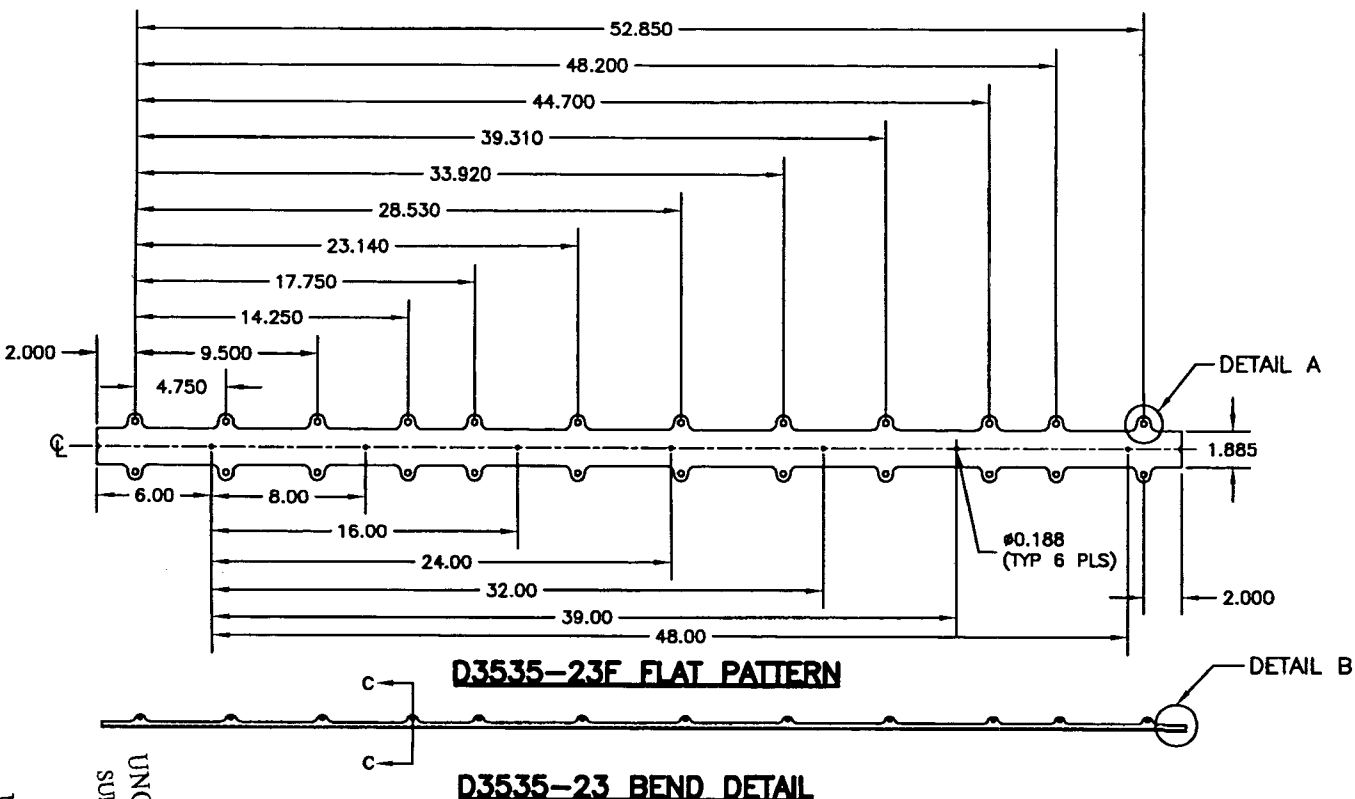
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.036 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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#	#	D3535	SHEET 3 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

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07.04.24



NOTES

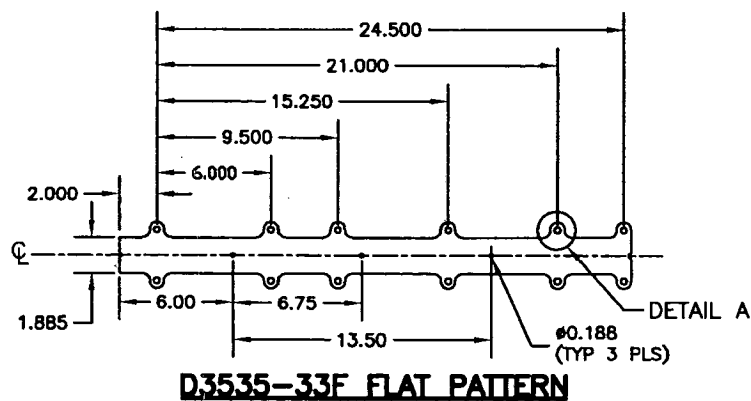
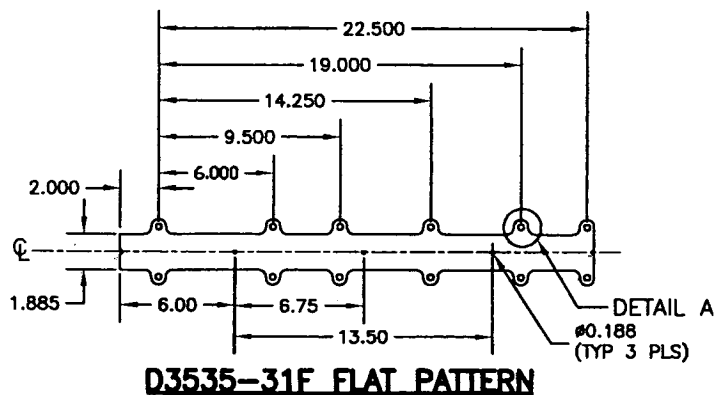
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
				SCALE 1:10



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NOTES

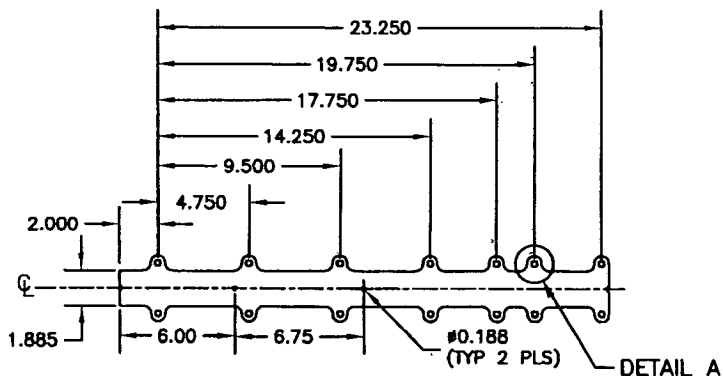
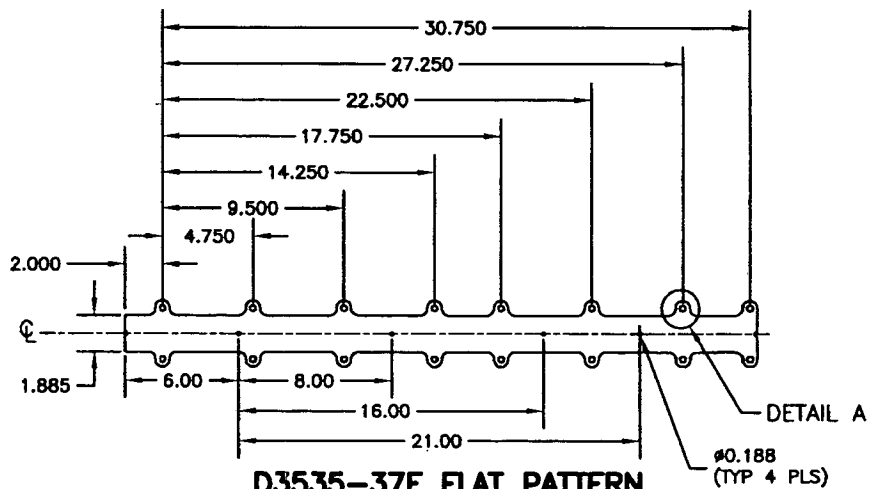
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDING (4.3.5.6) PER QSI 005 4.3
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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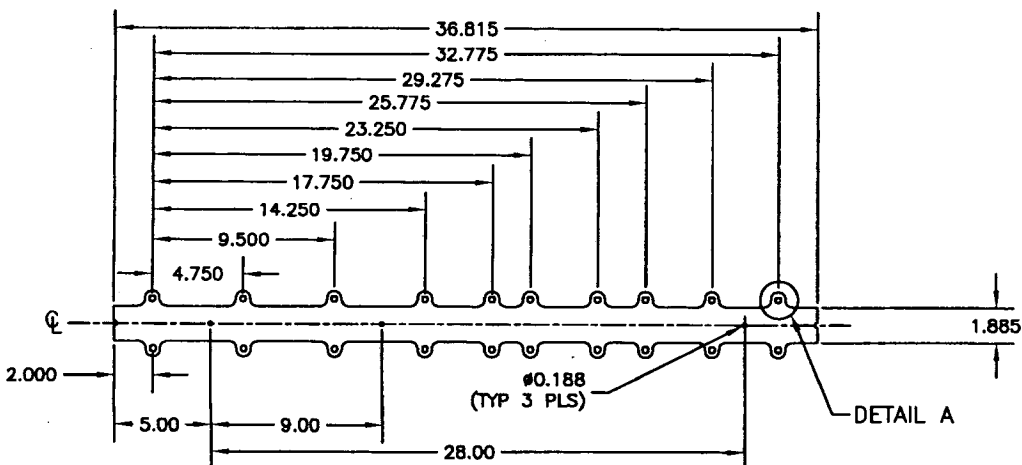
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DART

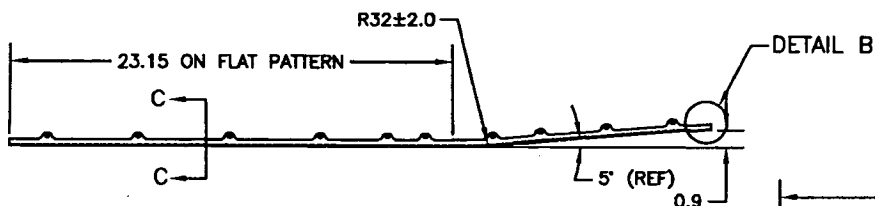
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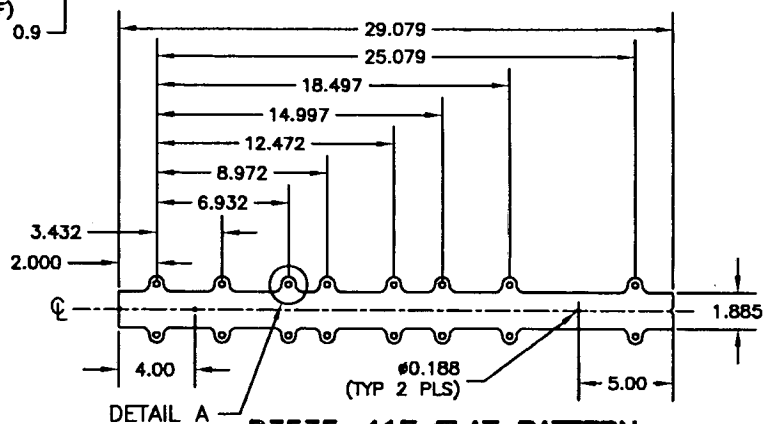
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



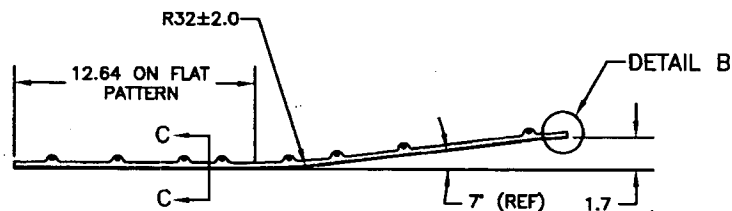
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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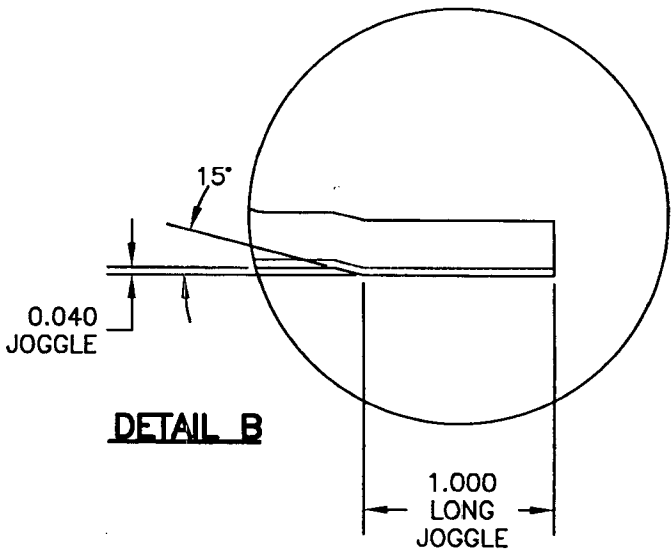
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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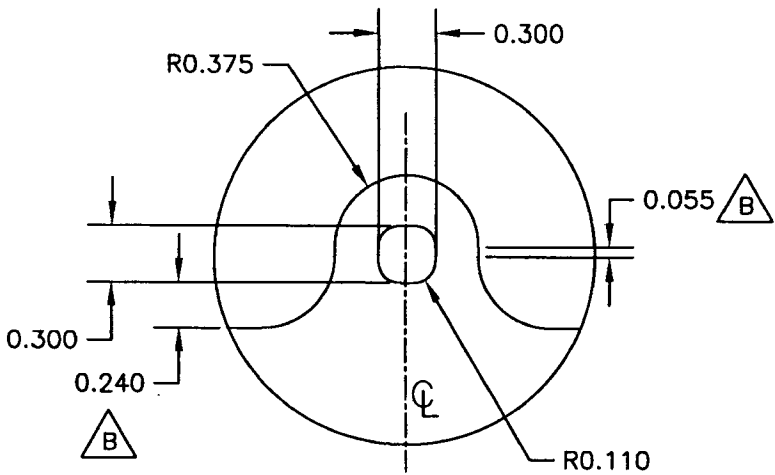


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3535
DATE	07.04.17			SHEET 7 OF 7
		TITLE	WEARSHOE	SCALE 1:1

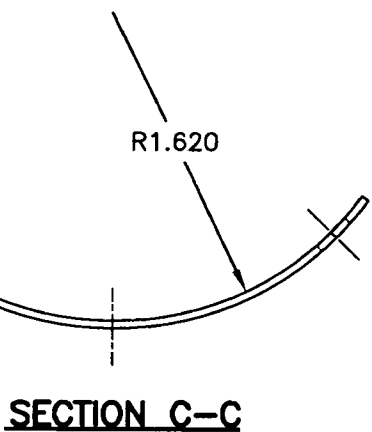
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DETAIL B



DETAIL A



SECTION C-C

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